

Work Order ID 140596

Friday, January 08, 2016 7:53:48 AM

140596

140596.

Page 1

Item ID: D3910-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID:
Item Name: Crosstube Lug Stop ***NS2***

Start Date: 1/21/2016 Start Qty: 20.00 ***20***

Cust Item ID:

Required Date: 1/21/2016 Req'd Qty: 20.00 ***20***

Customer:

Reference:

Approvals: Process Plan: CL Date: JAN 08 2016 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3910	E

110 Outsource process - Machining 0.00

110

HAAS CNC VERTICAL MACHINING #1

Outsource5

Memo

0.00

Outsource process - Machining

Issue P/O to Metec : 30973
Machine as per dwg
C of C is required

DAS

13

9-89

JAN 12 2016

20

120 Receive & Inspect for Damage & Mat'l Certs 0.00

120

Packaging

Memo

0.01

Packaging

Ensure C of C is attach

20 x SP/6-01-26

130 QC6- Inspect dimensions to drawing 0.00

130

QC

Memo

0.00

Quality Control

20

DAS

38

9-89

FEB 01 2016

Work Order ID 140596***140596***

Page 2

Friday, January 08, 2016 7:53:48 AM

Item ID: D3910-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Crosstube Lug
Start Date: 1/21/2016 Start Qty: 20.00 ***20*** Cust Item ID:
Required Date: 1/21/2016 Req'd Qty: 20.00 ***20*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo DAS 38 9-89 N/A	0.00 0.01							
150 *150* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo DAS 38 9-89 N/A	0.00 0.00							
160 *160* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-A Memo DAS 38 9-89 N/A START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____	0.00 0.00							

Work Order ID 140596***140596***

Page 3

Friday, January 08, 2016 7:53:48 AM

Item ID: D3910-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Crosstube Lug
Start Date: 1/21/2016 Start Qty: 20.00 ***20*** Cust Item ID:
Required Date: 1/21/2016 Req'd Qty: 20.00 ***20*** Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC3- Inspect Part Finish	0.00							
170									DAS
QC	Memo	0.00							38
Quality Control									9-89
									FEB 0 1 2016
180	Identify as per dwg & Stock Location: <u>5123</u>	0.00							
180									DAS
Packaging	Memo	0.00							6
Packaging									9-89
									FEB 0 5 2016
190	QC21- Final Inspection - Work Order Release	0.00							
190									DAS
QC	Memo	0.03							6
Quality Control									9-89
									FEB 0 8 2016

MCS FEB 0 8 2016

Picklist Print

Page 1

Friday, January 08, 2016 7:53:47 AM

Work Order ID: 140596

140596

Parent Item: D3910-1

D3910-1

Parent Item Name: Crosstube Lug

Start Date: 1/21/2016

Required Date: 1/21/2016

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD IPP
REV:B AS PER REV B 10-03-23 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3910-1P		Purchased	No				Each	0.0000		20			
D3910-1P									**				
Crosstube Lug													
D2423		Manufactured	No				f	354.9205		2.736842			
D2423									**				
Lug Extrusion													

20X 8016-01-26

DAS
13 JAN 12 2016
9:09LocationLoc QtyLoc Code

Metec

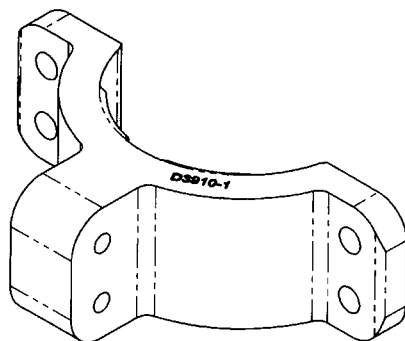
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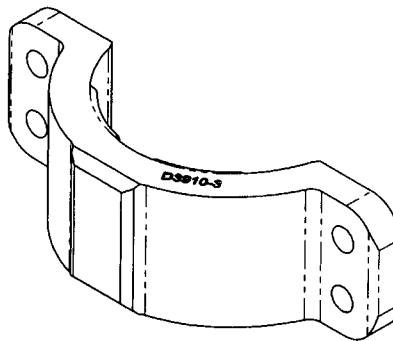
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131451

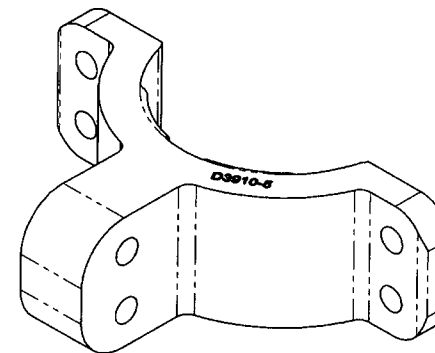
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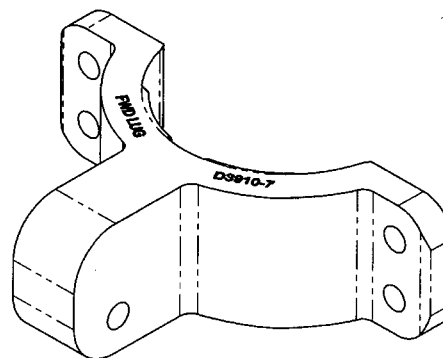
D3910-1 X-TUBE LUG



D3910-3 X-TUBE LUG



D3910-5 X-TUBE LUG



D3910-7 X-TUBE LUG

STOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 140596 MLS

16-01-07

RELEASED

2014 JUN 05
ECN 14-572

NOTES:

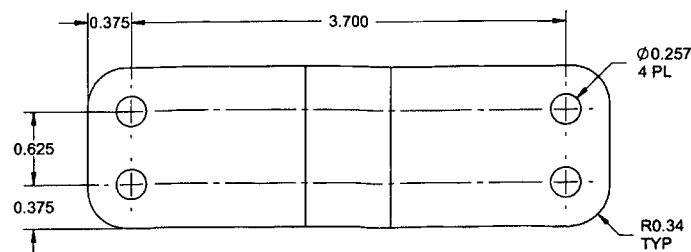
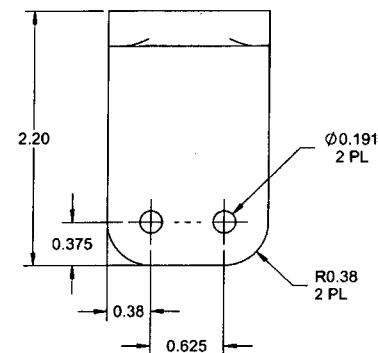
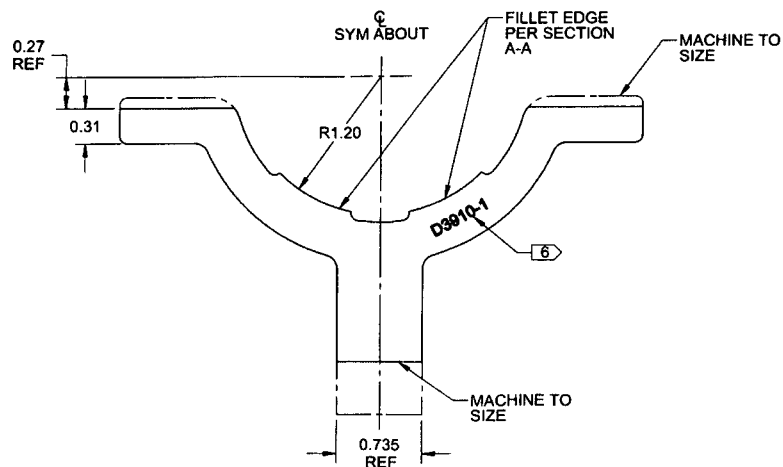
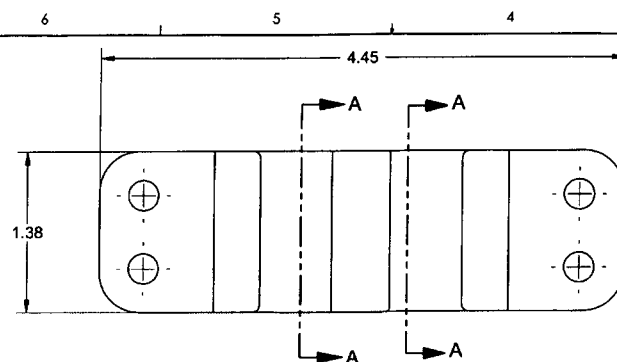
- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 $\pm$ 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS
OF 0.015 $\pm$ 0.005
- 7) WEIGHT -1: 0.32 lbs
-3: 0.25 lbs
-5: 0.36 lbs
-7: 0.37 lbs
- 8) IDENTIFICATION: ENGRAVE "FWD LUG" TO A DEPTH OF 0.010 $\pm$ 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS
OF 0.015 $\pm$ 0.005

E	ADD -7 PER NCR14-3871	AJS	14.05.16
D	CHANGED FASTENER HOLES IN -5 FOR 1/4" HARDWARE. REASON: EASE OF INSTALLATION.	AJS	13.08.14
C	ADD -5.	AJS	13.08.08
B	Ø0.257 HOLES: 4 PL WAS 2 PL (A3-2) & (A3-3); R0.34 FILLET WAS R0.50 (A3-2) & (A3-3). REASON: SEE TR-D350-507-2	JPH	10.03.16
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	JPH	DRAWING NO.	REV. E
MFG. APPR.	JPH	D3910	SHEET 1 OF 5
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	X-TUBE LUG (350)	NTS
DATE	14.05.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



ROUND EDGE
R0.06 MIN - R0.10 MAX
2 PL

SECTION A-A



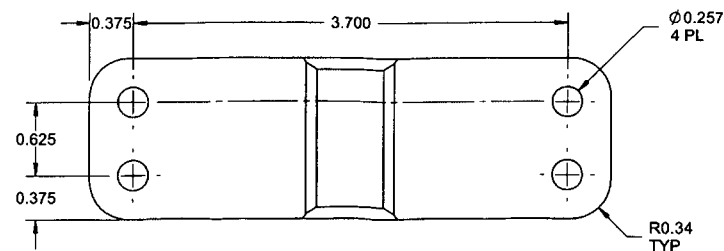
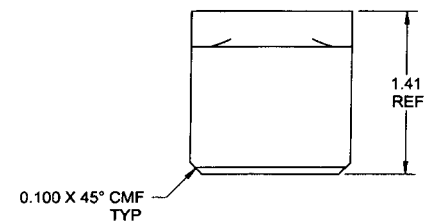
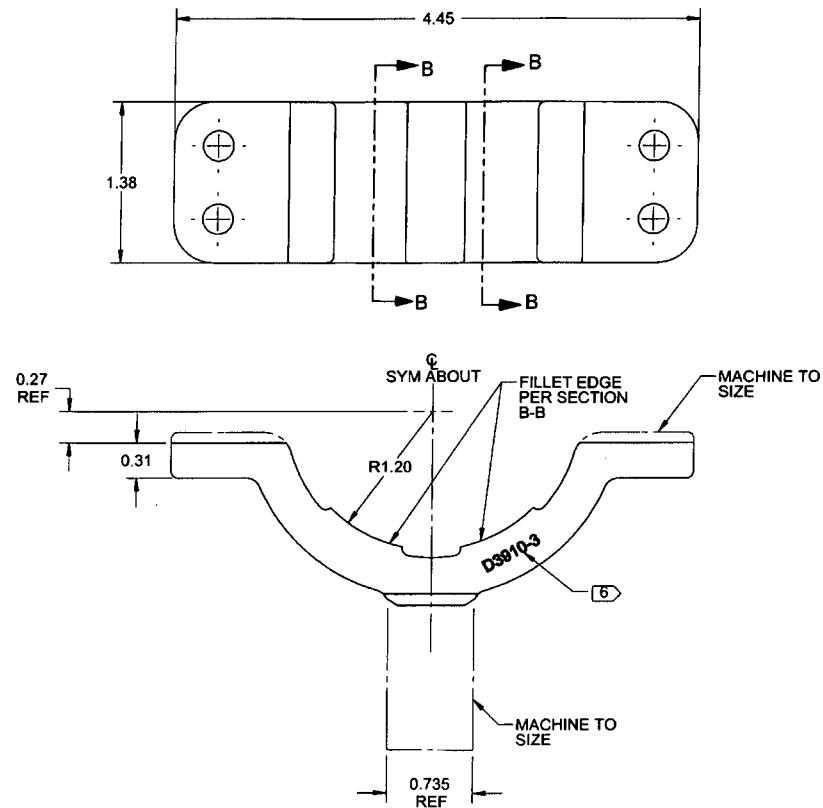
D3910-1 X-TUBE LUG

RELEASED

2014 JUN 05 *q*

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3910	REV. E SHEET 2 OF 5
MFG. APPR.	<i>[Signature]</i>	TITLE X-TUBE LUG (350)	SCALE NTS
DE APPR.	<i>[Signature]</i>	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	14.05.16		

SECTION B-B
 ROUND EDGE
 R0.06 MIN - 0.10 MAX
 2 PL



D3910-3 X-TUBE LUG

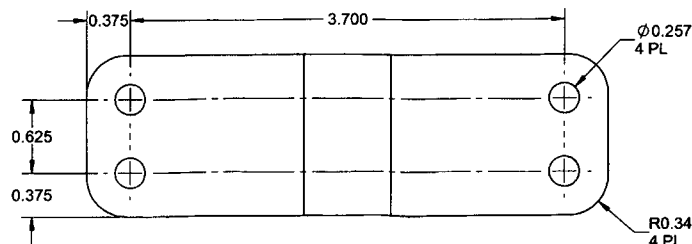
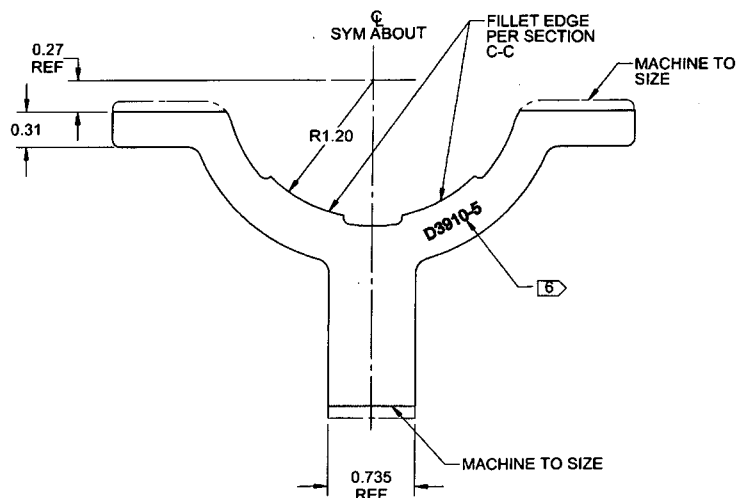
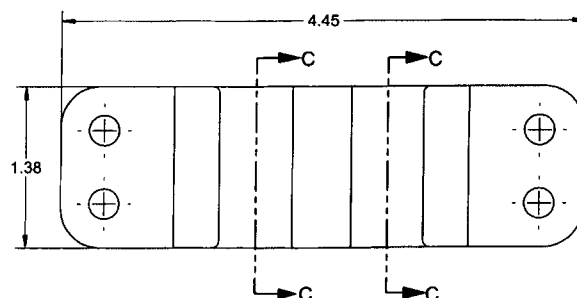
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MFG. APPR.	<i>[Signature]</i>	D3910	SHEET 3 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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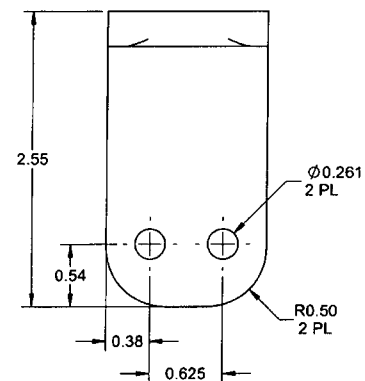
SECTION C-C



ROUND EDGE
R0.06 MIN - 0.10 MAX
2 PL



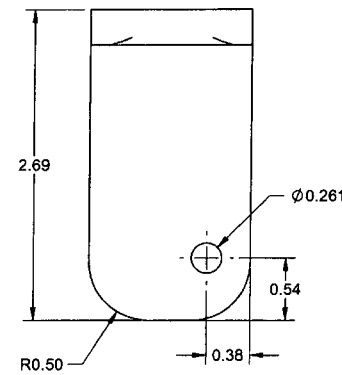
D3910-5 X-TUBE LUG



RELEASED

2014 JUN 05

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MFG. APPR.	<i>[Signature]</i>	D3910	SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	X-TUBE LUG (350)	NTS
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DRAWN	AJS		SHEET 5 OF 5
CHECKED	<i>[Signature]</i>		SCALE
MFG. APPR.	<i>[Signature]</i>		NTS
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	14.05.16		

DART
AEROSPACE

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO30973

Purchase Order Date 1/12/2016

PO Print Date 1/13/2016

Page Number 2 of 4

Order From :

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, ON K0B 1R0
CA

VC-MET003

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613 678 3957

Ship To Contact

Ship To Phone

Ship Via: Dart Truck

Ship Acct:

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 10

CAD

Destination-Collect

3	D2731-3P	Lug	2/2/2016 Yes 2/2/2016	32.00 Each	\$13.00	\$416.00
---	----------	-----	-----------------------------	---------------	---------	----------

AS PER DWG D2731 REV. C
B140246
ALODIDE AND PAINT AS PER QSI 005

Line Total: \$416.00

4	D3235-1P	Lug	2/2/2016 Yes 2/2/2016	50.00 Each	\$15.00	\$750.00
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AS PER DWG D3235 REV. A
B140546
ALODIDE AND PAINT AS PER QSI 005

Line Total: \$750.00

5	D3910-1P	Crosstube Lug	2/2/2016 Yes 2/2/2016	20.00 Each	\$16.10	\$322.00
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AS PER DWG D3910 REV. E
B140566
ALODIDE AND PAINT AS PER QSI 005

Note:

1/13/2016



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 21079
Date: Jan 25, 2016
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: PO 30973	Sold By: Walz, Christian D.
Shipped By: your truck	Ship Date: Jan 25, 2016

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2731-3 Mounting Lug	Each	32		
D3235-1 Mounting Lug	Each	50		
D3910-1 Crosstube Lug	Each	20	20	
D2230-1 Mounting Lug	Each	100		
D2230-3 Mounting Lug	Each	150		
D3910-3 Crosstube Lug	Each	20	20	
D3910-7 Crosstube Lug	Each	10		
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by _____		Thank you for your order!		



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0
Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

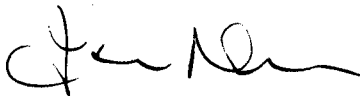
<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
20	D3910-1 ✓	Lug	30973
20	D3910-3	Lug	30973

Paint Batch # 20258
MATERIAL: supplied by DART B131451

8/16/26

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Jan Norris

Vankleek Hill, January 25, 2016